



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

SWA25A-210
Job Sheet 175646



Part No: SWA25A-210

Job Qty: 3 ea

Part Name: Upper End Swivel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/10/18

Job Tracking No:

Due Date: 4/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA25A-210 REV:6 IPP REV A 18.02.20 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	4/19/18	4/19/18	0.00	0.00	Start Up Machining-3		<i>m</i> 4/18/18/10
122	CNC Vertical Machining	3 pcs	4/20/18	4/20/18	0.00	3.00	MORI NV5000-1		<i>m</i> 4/18/18/10
124	QC	3 pcs	4/20/18	4/20/18	0.00	0.00	QC2 Machining-3		<i>m</i> 4/18/18/10
130	QC	3 pcs	4/20/18	4/20/18	0.00	0.00	QC8		<i>m</i> 4/18/18/10
140	Packaging	3 pcs	4/20/18	4/20/18	0.00	0.00	Packaging3		<i>m</i> 4/18/18/10
150	QC21-SA	3 Ea	4/20/18	4/20/18	0.00	0.00	QC21		<i>m</i> 4/18/18/10

Part Op 122 - -Use SWA25A-200 and modify groove as per DWG 1-Machine as per DWG. FB902 FOLIO REV: _____
Descriptions: DWG REV: _____ 2-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
SWA25A-200P	Upper End Swivel	3 pcs (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	SWA25A-200P	3	5	0

Part Specifications

Specifications could not be found.



Container No: S059808



Part: SWA25A-210

Job No: 175646

Serial No/Batch: S059808

Revision: 6

Inspector:

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Plex 4/10/18 7:31 AM Dart.lajeunesse.marie

Date: 04/10/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



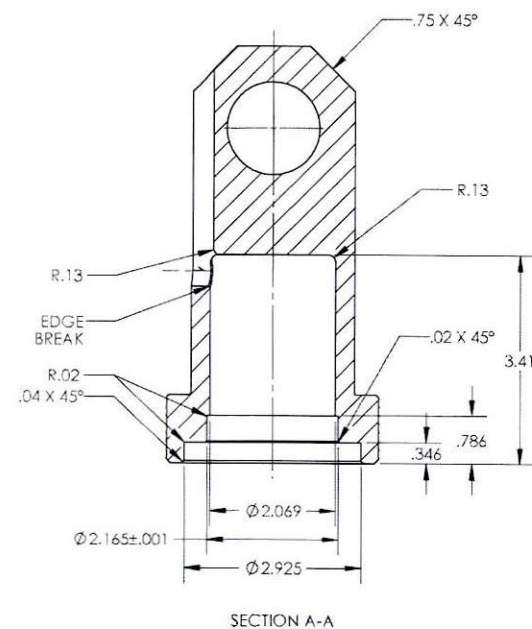
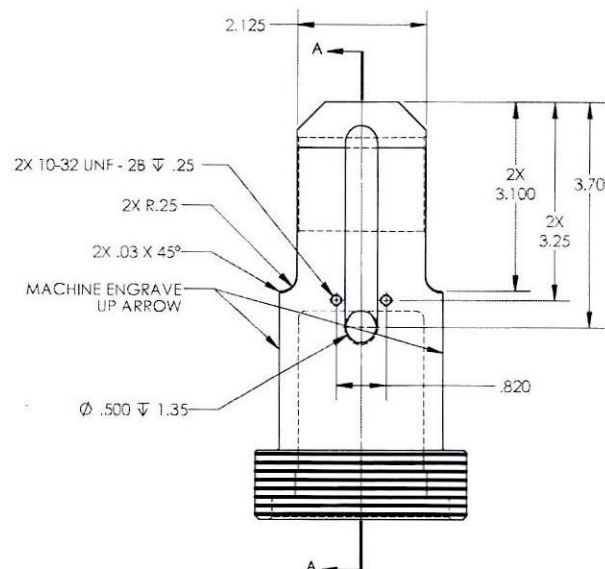
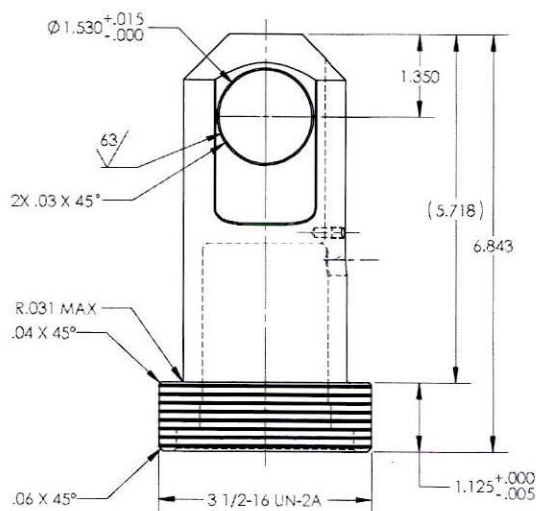
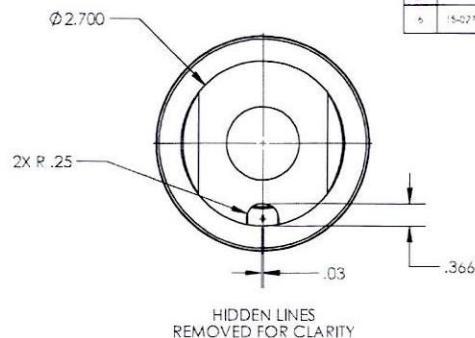
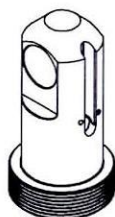
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5		AS DRAWN BY CANAM	11/12/2012	JAC	
5A		CHD B/D INFO TO B. ANK	4/29/2014	JAC	RW
6	15-0718	UPDATED TO NEW DRAWING STANDARDS, ADDED UP ARROW NOTE, ADDED MATL OPTION H12/5 ADDED DWG FROM SWA12A-200 BLANK DWG.	6/17/2015	DPD	JAC



ASSY QTY	ASSY QTY	B/D	Part #	UNIT QTY	Description	Material	B/D INFORMATION OR SPECIFICATIONS
			SWA25A-210	1	UPPER END SWIVEL	SS 17-4, H1150/H1075	

DART AEROSPACE	
TITLE UPPER END SWIVEL	
DWG NO. SWA25A-210	REV 6
MATL: SS 17-4, H1150/H1075	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED: <i>P. Wood</i>
XXX ± .005 FRACTIONS ± 1/8	REAT
XX ± .01 ANGLES ± 5°	TREAT
X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45°	SPEC
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:2	DATE 2/22/2002
SHEET 1 OF 1	